

Work Order ID 56258

Wednesday, February 17, 2010 11:04:33 AM

Page 1

Item ID: D2916-3

Accept

Setup Start

Revision ID:

Item Name: Cable Guard, 212 Skitube

Stop

Start Date: 2/18/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 3/4/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2916

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2916 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

B 10-2-17

⑥

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-2-17

120

HAAS CNC VERTICAL MACHINING #1

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

BATCH: 113166 ☐ 1- Mill as per Folio FA2916-3 Rev:
A & Dwg D2916 Rev: B ☐ 2-Deburr per dwg D2916

cm 10/02/23

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

an 10/02/23

6 5

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

MMZ 10/02/23

6 5

150

Identify as per dwg & Stock Location: 257

0.00



Packaging

Memo

0.00

Packaging

10/3/01 (4)

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/03 DJ
CY 03/01/10

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Picklist Print

Wednesday, February 17, 2010 11:04:33 AM

Page 1

Work Order ID: 56258



Parent Item: D2916-3



Parent Item Name: Cable Guard, 212 Skitube

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev:A New Issue 06-06-19 JLM
IPP Rev:B Now water jet 06-07-14 EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			100	sf	457.9905	2.3158	4.		
UHMW 1" Black												

B10-2-17

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	426.2428	
112186	122.0164	
113166	28.6264	
113903	275.6	
Main Warehouse		
ST	31.7477	
111354	31.7477	

(6)

113166

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	30250
Description: Cable Guard		Part Number:	D2916-3
Inspection Dwg: D2916	Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

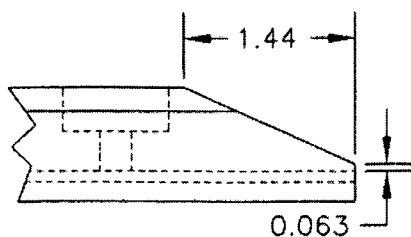
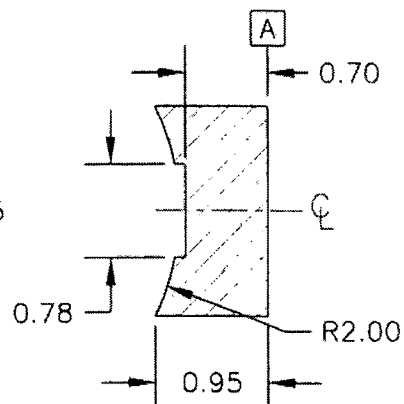
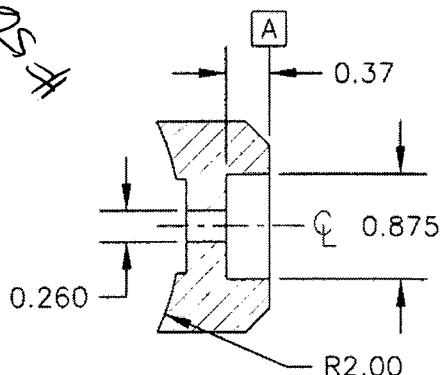
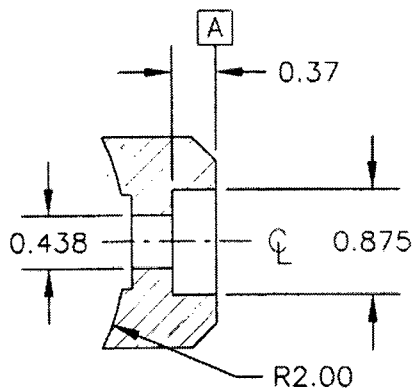
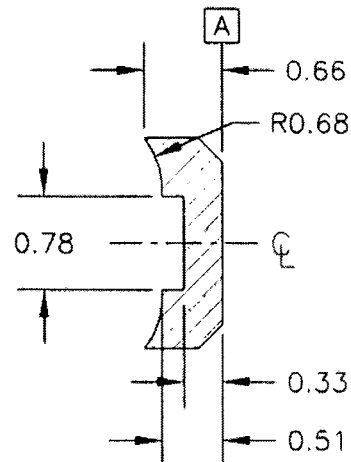
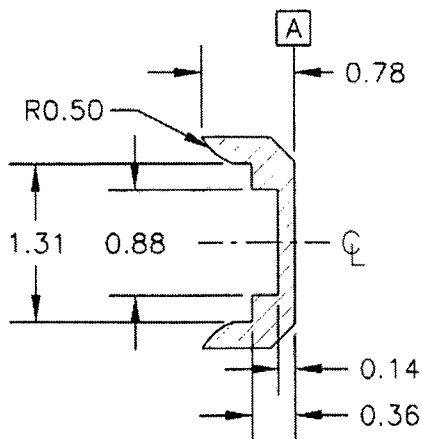
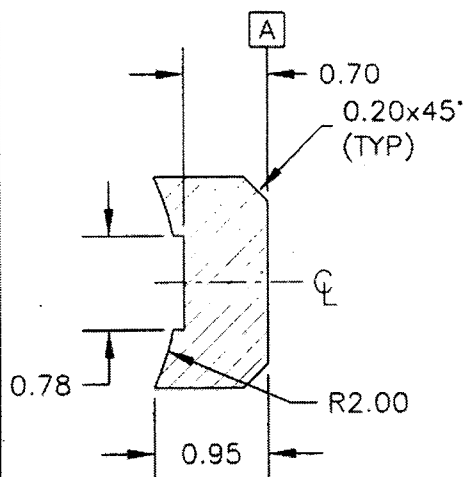
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Measured by: <i>RM</i>	Audited by: <i>MMW</i>	Prototype Approval:	N/A
Date: <i>10/02/23</i>	Date: <i>10/02/23</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue P/O D205-665-015	KJ/RF	[Signature]



DESIGN #	DRAWN BY P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2916	REV. B SHEET 1 OF 2
DATE 00.02.24		TITLE CABLE GUARD	SCALE 1:6
A	99.09.29	NEW ISSUE	
B	00.02.24	ADD K-K FOR D2521 COMPATIBILITY	



DETAIL J
(SCALE 2:3)

RELEASED
00.02.25 DS

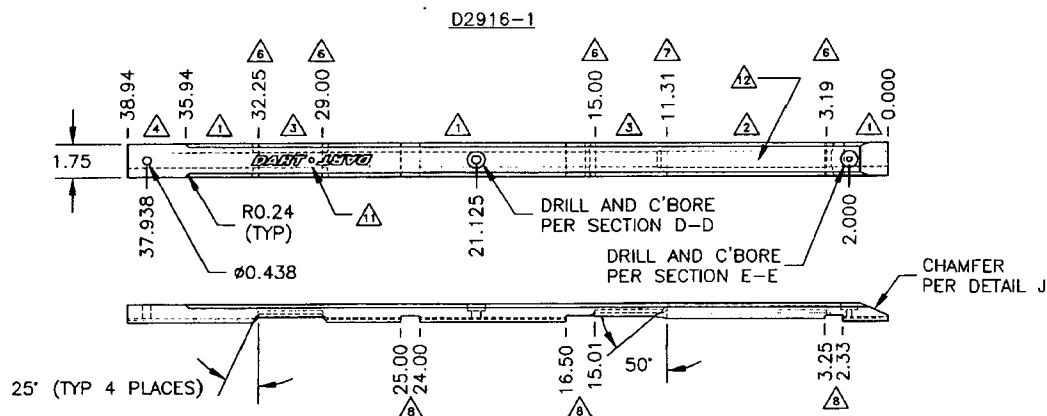
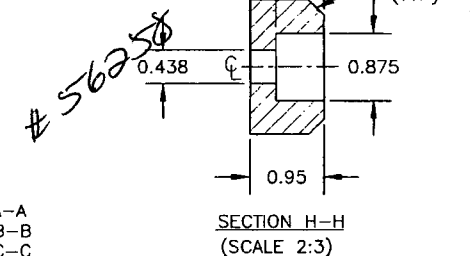
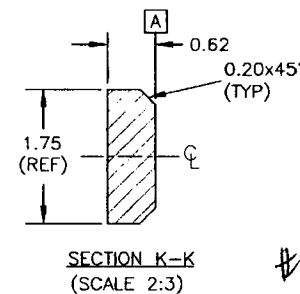
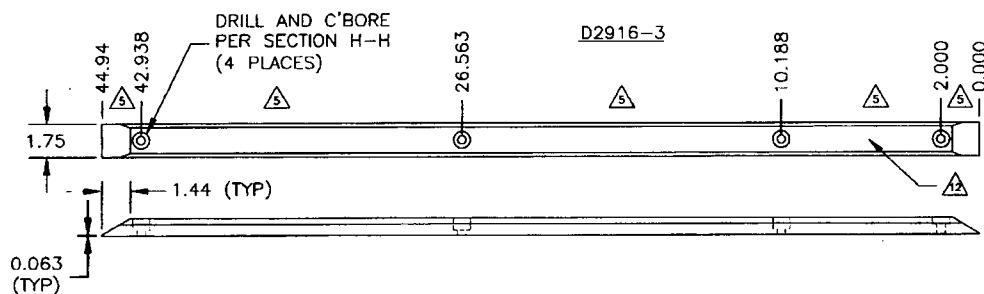
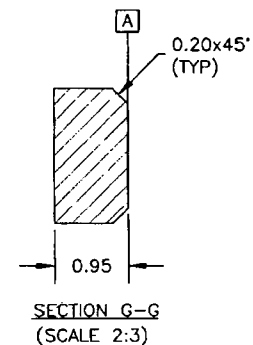
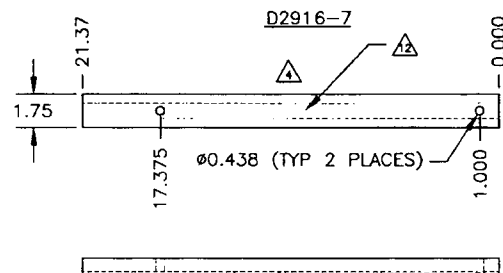
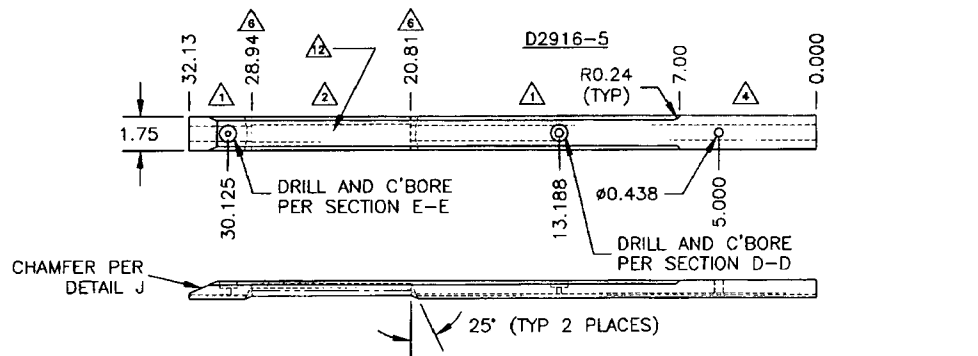
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NOTES:

- 1) MACHINE CONSTANT SECTION A-A
- 2) MACHINE CONSTANT SECTION B-B
- 3) MACHINE CONSTANT SECTION C-C
- 4) MACHINE CONSTANT SECTION F-F
- 5) MACHINE CONSTANT SECTION G-G
- 6) 25° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
- 7) 50° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
- 8) MACHINE SLOT PER SECTION K-K WITH 0.063 RADIUS OF TRANSITION BETWEEN SECTIONS
- 9) MATERIAL: UHMW BLACK PER SPEC CONTROL DWG D2689
- 10) BREAK ALL UNMARKED RADII 0.020 TO 0.040
- 11) ENGRAVE TWO DART LOGOS (OPPOSITE AS SHOWN) ON UPPER SIDE TO MAX DEPTH OF 0.015 AND MIN RADIUS OF 0.250.
- 12) ENGRAVE P/N ON LOWER SIDE TO MAX DEPTH OF 0.010 AND MIN RADIUS OF 0.010.
- 13) ALL HOLES DRILLED ON CENTERLINES
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 15) ALL DIMENSIONS ARE IN INCHES

RELEASED
100-62-25-03

DESIGN #	DRAWN BY P	DART DART AEROSPACE LTD WARRICKSBURY, OXFORD, GLOUCESTER
CHECKED #	APPROVED #	DRAWING NO. D2916 REV. B SHEET 2 OF 2
DATE 00.02.24	TITLE CABLE GUARD	SCALE 1:6

W/O:		WORK ORDER CHANGES					
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